

Date: Monday, 02/02/2009 11:50:02 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)		
Job Number	: 45391		Part Number	: D2602 D2601-2		
Estimate Number	: 11001		Drawing Number	: D2602 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	02/02/2009	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	1 /	Type : SMALL /MED FAB	Due Date	12/02/2009	Qty:	4 Um: Each
Previous Run	: 44392					
Written By	:					
Checked & Approved By	: JCO 09.02.02					
Comment	: Est. E 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-1 Est Rev:E Now On Waterjet 07-03-22 JLM Est Rev:F RevB as per dwg ECN1059 DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet  Comment: Qty.: 1.4146 sf(s)/Unit Total : 5.6582 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>110337</u> <u>B 9-2-12</u>
2.0	WATER JET	FLOW WATER JET  Comment: FLOW WATER JET 1-Cut as per Dwg D2602 *****Same Cutting File for -1 & -2 ***** Dwg Rev: <u>B</u> <u>B 9-2-12</u> Prog Rev: <u>B</u> <u>B 9-2-12</u> 2-Deburr if necessary <u>B 9-2-12</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK  Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2601-2 PAR #: N/A Fault Category: Prod/Eng Coord. NCR: Yes No DQA: Date: 09/03/02
 Resolution: Doc. Revised Disposition: Re-worked QA: N/C Closed: Date: 09/03/02

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-03-02	2.0	Incorrect parts made. D2602 as D2601. Employee worked off of the drawing, and the incorrect drawing was attached. Affected W/O's: 45390, 44391, 45391, 44392	<input checked="" type="checkbox"/> 09/03/02	- See NCR 09-02 - update W/O to D2601	<input checked="" type="checkbox"/> 09/03/02	<input checked="" type="checkbox"/> 09/03/02	<input checked="" type="checkbox"/> 09/03/02	<input checked="" type="checkbox"/> 09/03/02

NOTE: Date & initial all entries

Date: Monday, 02/02/2009 11:50:02 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE 4 (206 HI-SLOPE)

Job Number: 45391

Part Number: D26022 D2601.2

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D2602

SB 09/03/04

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



X7

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

LMP/BR.

09/03/09

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AM 09.03.06 (7)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



7K

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9/3/10

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



09/03/10 SP

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44391
Description: CONSOLE SIDE		Part Number:	D2601-2
Inspection Dwg: D2601-2 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Φ .098	+ .004 - .001	.101	X			
13.00	+ .30	12.981	X			
1.35	+ .30	1.352	X			
1.375	+ .010	1.372	X			
.300	+ .010	.301	X			
6.000	+ .010	5.994	X			
9.45	+ .030	9.45	X			
10.96	+ .030	10.90	X			
8.875	+ .010	8.878	X			
.340	+ .010	.338	X			
.500	+ .00	.500	X			
.878	+ .00	.880	X			
1.254	+ .010	1.247	X			
2.47	+ .030	2.483	X			
.92	+ .030	.911	X			
11.239	+ .010	11.221	X			
10.76	+ .030	10.694	X			
13.75	+ .30	13.75	X			
14.18	+ .030	14.18	X			
.838	+ .00	.838	X			
2.648	+ .010	2.650	X			
.040	+ .010	.046	X			

Measured by:	B	Audited by:		Prototype Approval:	N
Date:	9-3-04	Date:	09/03/04	Date:	09/03/04

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

